Qty:

Q.A

Friday, 21/12/2007 2:45:24 PM

User:

Linda Lacelle

## **Process Sheet**

**Drawing Name** 

**Part Number** 

Material Due Date

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: BUSHING

: D28063

: N/A

: D2806 REV A

: 15/01/2008

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 36534

**Estimate Number** 

: 10518

P.O. Number

This Issue

Prsht Rev.

First Issue

Written By

Comment

**Previous Run** 

: NA

: 21/12/2007

Type

S.O. No. : \*

: MACHINED PARTS

: Est:B 05.03.11 Part now turned KJ/JLM

**Additional Product** 

Checked & Approved By

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 1" HexBar

4.8090 f(s)

1.0

3.0

M6061T6H1000

Total:

Comment: Qty.: 0.0962 f(s)/Unit 6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: M 105 2 3 8

2.0 HARDINGE

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





PARTS AS THEY COME OFF MACHINE 4.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

5.0

SECOND CHECK

Comment: SECOND CHECK

QC8

H. A Konfoslos

Each

50 Um:

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							:		
Part No	•	PAR #: Fault Category:	NCR: Yes	No po	A. 15	Date: C	Blall		

QA: N/C Closed: \_\_\_\_ Date: \_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	3	Verification	Annroval	Ammental		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
		·			·					
							•			

NOTE: Date & initial all entries

Date: Friday, 21/12/2007 2:45:24 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: BUSHING** Job Number: 36534 Part Number: D28063 Job Number: Seq. #: Machine Or Operation: Description: HAND FINISHING1 6.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT ALODINE 8.0 PACKAGING 1 PACKAGING RESOURCE # Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 9.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion Le 8.01.11

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							:			
Part No	: 	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _				
			QA:	N/C Close	ed:	Date:				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	Annroyal	Anneous		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
·										
\			ļ					i		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 36534
Description: BUSHING	Part Number: D28063
Inspection Dwg: 280 (a Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

× First Article Prototype
---------------------------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/010"	1,006	✓		,	
0.495	+0.00007	0.4935	<b>✓</b>			
3.250	+/010"	0.255"	✓			
Ø.750	+ 0.000	0.447	<b>/</b>			
0.063 x 45°	7/010"	0.063 k45°	<b>✓</b>			
0.080 × 45°	+/010"	0.045"	~			
R 0.010	1/- 0.005	R0.010"	/			
1. 155	+/010	1.145	<i>J</i>	ļ		
	·					
\$ 0.316	+.00G 0000	,320				Marcal
0.094	+/- 0.010"	,094				Manhal
					,	
		-				
		· ·				

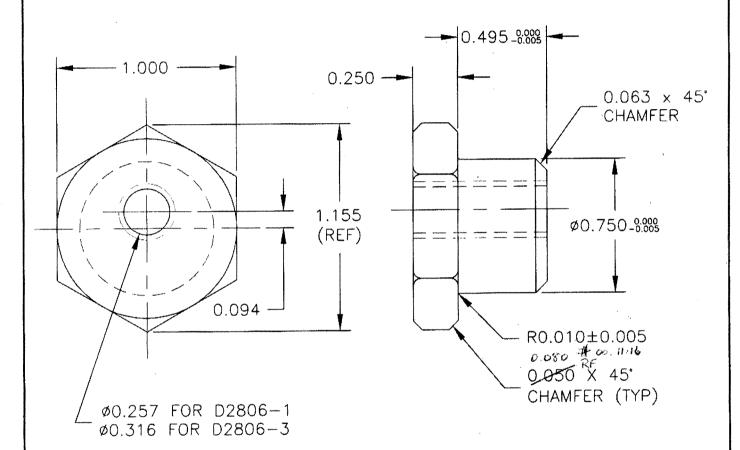
Measured by: H.A.	Audited by:	Prototype Approval:	
Date: 08/01/02	Date: 08/01/02	Date:	<u> </u>
	•		

1	Rev	Date	Change	Revised by	Approved
١	Kev	Date	Ollange	KJ/RF	1
Ì	Α		New Issue	1/0/1/1	<u></u>





	DESIGN	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
and the same of th	CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
	DATE	1 2	TITLE	SCALE
	00.11.08		BUSHING	2:1
	Δ	00 11 08	NEW ISSUE	



D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE) W/03653V

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace L	∟ta	ı
------------------	-----	---

W/O:		WORK ORDER CH	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>							
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	<b>A</b> :	Date:	

Part No:	PAR #: Fault Categor	r: NCR: Yes No	DQA:	Date:
		QA: N/C	Closed:	Date:
NCR:	WORK ORDER	NON-CONFORMANCE (NCR)		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP	Description of NC		Corrective Action Section B		Verification	Approval	Approval			
	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
		·								
		·								
•										

NOTE: Date & initial all entries